

Date: Wednesday, 4/5/2006 3:24:55 PM
 User: Kim Johnston

Process Sheet

18

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PILOT/CO-PILOT STEP, LH (FOLDING)
 Job Number : 26551
 Estimate Number : 12026
 P.O. Number : N/A Part Number : D412630023
 This Issue : 4/5/2006 S.O. No. : N/A Drawing Number : D412-630 REV. J, P13
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : J
 Previous Run : 26135 Material : N/A
 Due Date : 5/5/2006 Qty: 1 Um: Each
 Written By: *See Comment Below*
 Checked & Approved By : *06.04.06*
 Comment : Est. Rev: B 05.08.22 Step 3 & 5 revised per ECN 700 KJ/J
 LM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
 Photocopy bluefile & create labels per PPP D412-630-023 CHG002

KS 06.04.26 (27)

2.0 D2012107 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description	Batch
1	D2012-107	Clevis	<i>B25483</i>

3.0 D2803041 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2803-041	Bracket Assembly LH	<i>B25917</i>

4.0 D2804041 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2804-041	Bracket Assembly LH	<i>B23435</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 26551

Part Number: D412630023

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2807

Support Prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Support Prop

Pick:

Qty Part Number

Description

Batch

2 D2807

Gas Spring

B26646

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

2 D2813

Washer

B26649

7.0

D3388041

Step Weldment LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Step Weldment LH

Pick:

Qty Part Number

Description

Batch

1 D3388-041

Step Weldment LH

B26156

8.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bushing

Pick:

Qty Part Number

Description

Batch

4 D3395-1

Bushing

B25935 (2) B27291

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

BOLT

Pick:

Qty Part Number

Description

Batch

2 AN3C21A

Bolt

M19633

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 26551

Part Number: D412630023

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
2	AN310C8	Nut

Batch

M100433

11.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

M100695

12.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M100218

13.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M16941

14.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M16984

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 26551

Part Number: D412630023

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

M19633

16.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M100050

17.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M100446

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.13

SAD 06.06.13

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 06.13

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 26551

Part Number: D412630023

Job Number:



Seq. #:	Machine Or Operation:	Description :
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21.0	D28061	Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~10.0000~~ 8 Each(s)
Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-1	Bushing	B26565

✓

22.0	D28063	Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~10.0000~~ 8 Each(s)
Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-3	Bushing	B26160

✓

23.0	D28105	Strut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~5.0000~~ 4 Each(s)
Strut

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2810-5	Strut	B26758

✓

24.0	D33961	Spacer
------	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~10.0000~~ 8 Each(s)
Spacer

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D3396-1	Spacer	B26654

✓

25.0	AN4C6A	Bolt
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~5.0000~~ 4 Each(s)
Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C6A	Bolt	M19512

✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/5/2006 3:24:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 26551

Part Number: D412630023

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~5.0000~~ Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

1 AN4C10A

Description

Bolt

Batch

M18515 ✓

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~10.0000~~ Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

2 AN4C15A

Description

Bolt

Batch

M100 036 ✓

28.0

AN44C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~5.0000~~ Each(s)

Eyebolt

Pick: Packing Kit

Qty Part Number

1 AN44-C7A

Description

Eyebolt

Batch

M19620 ✓

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~10.0000~~ Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

2 AN5C15A

Description

Bolt

Batch

M18167 ✓

30.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : ~~20.0000~~ Each(s)

Nut

Pick: Packing Kit

Qty Part Number

4 MS21043-4

Description

Nut

Batch

M100651 ✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		2.1		2.1		2.1		

NOTE: Date & initial all entries

Date: Wednesday, 4/5/2006 3:24:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 26551

Part Number: D412630023

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : ~~45~~¹² 0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number Description Batch

3 MS21043-5 Nut M18535

✓

32.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : ~~35~~²⁸ 0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number Description Batch

7 NAS1515H4 Washer M100680

✓

33.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : ~~35~~²⁸ 0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number Description Batch

7 NAS1515H5 Washer M19565

AL 06/06/13

AL 6/12(4)

✓

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AL 06/06/13

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-023

Location:

PPP Rev: A

AL 06/06/14 (4)

36.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AL 06/06/15 (4)

Job Completion



u 06.06.15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

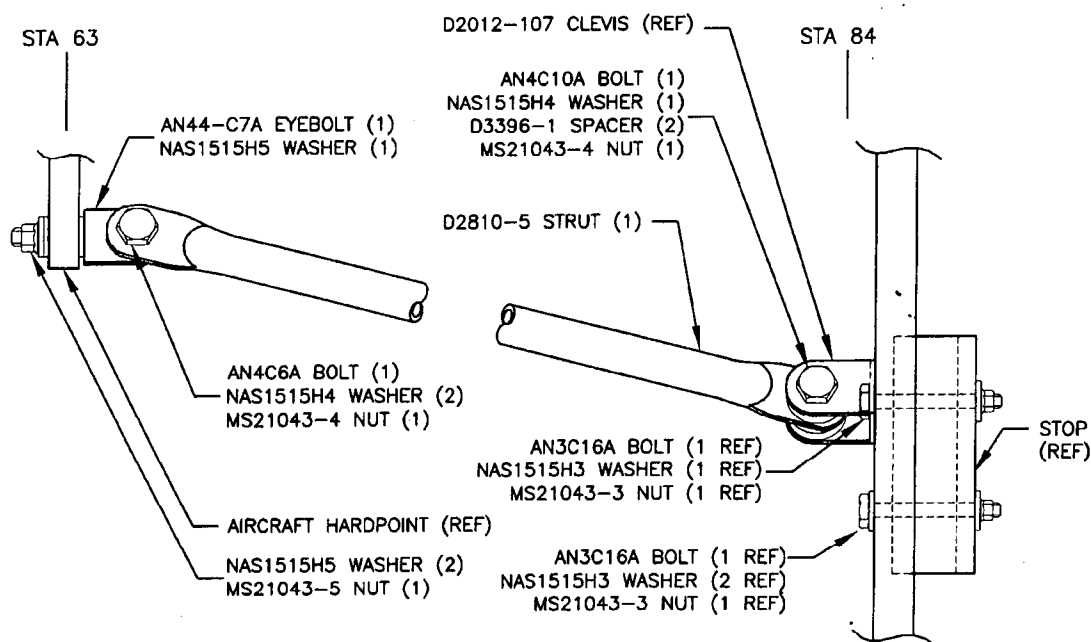
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

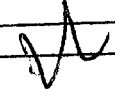
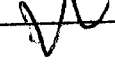
FIGURE 13 – Strut Detail for D412-630-023/-024 *Heli-Access-Step*™ Installation
(NOT TO SCALE)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26551

Date: Friday, 12/01/2007 3:00:13 PM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D412-630 - ECN 903
Job Number	: 30251	Part Number	: Z_CUSTOM
Estimate Number	: 10804	Drawing Number	: UPDATE PAPERWORK
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 12/01/2007 S.O. No. : N/A	Drawing Revision	: N/A
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 19/01/2007
Previous Run	: 30247	Type	: OVERHEAD
Written By	: 	Qty:	1 Um: Each
Checked & Approved By	: 		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ADD NEW PAPERWORK TO KITS IN STOCK
JCAB STC STC-112-2-TYO

D412-630-011 B 1370 2^{ix}, B 20227 2^x = 3 stx
 D412-630-012 B 1370 1^x B 20228 2^x
 D412-630-023 B 26551 1^x B 27271 2^x B 27267 3 B 27088 1^x = 5 stx
 D412-630-024 B 28197 2^x B 27089 1^x B 27269 1^x = 4 stx
 D412-630-111 B 15054 2^x
 D412-630-112 B 15055 2^x

Signature 07/01/15 07/01/15

2.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/15

Job Completion



u 07-01.15

Date: Monday, 12/11/2007 8:31:02 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D412-630-UPDATE PAPERW.
Job Number	: 35612		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: Z_CUSTOM
This Issue	: 12/11/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: ECN 1019
First Issue	: N/A	Project Number	: N/A
Previous Run	: 00015	Drawing Revision	: N/A
	Type : LANDING GEAR	Material	: N/A
Written By	:	Due Date	: 19/11/2007
Checked & Approved By	:	Qty:	1 Um: Each
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 REMOVE FROM STK:

D412-630-011G 34656
 D412-630-012G 34657
 D412-630-023 31816 (X) 27271 2x 26651 1x
 D412-630-024 32000
 D412-630-033 B 33576
 D412-630-034 B 33577

ADD NEW PAPERWORK TO KITS IN STK
 PER ECN 1019 - DSI 9386

RETURN TO STK

7-11-12 50

2.0	QC21	FINAL INSPECTION/W/O RELEASE
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①

Comment: FINAL INSPECTION/W/O RELEASE

207/11/12

Job Completion



u 07.11.12